

Date: Wednesday, 8/20/2008 10:08:30 AM
 User: David Duval

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : ACCESS PANEL
 Job Number : 05038
 Estimate Number : 13556
 P.O. Number :
 This Issue : 8/20/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D37055
 First Issue : 11 Type : SMALL /MED FAB Drawing Number : D3705 PROTO 08.08.20
 Previous Run : Material :
 Written By : DA 08/08/20 Due Date : 8/27/2008 Qty: 1 Um: Each
 Checked & Approved By :
 Comment : Est Rev:A 08-08-20 new issue DD verified by:EC

PRELIMINARY ISSUE

~~PROTOTYPE~~

Additional Product

Job Number:



FOR ENGINEERING USE ONLY

Seq. #: Machine Or Operation: Description :

1.0 M6061T6S040 6061-T6 .040 Sheet



Comment: Qty.: 0.3281 sf(s)/Unit Total : 0.3281 sf(s)
 6061-T6 .040 Sheet
 batch 106747 RB 8-8-20

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg D3705
 Dwg Rev: PREL.
 Prog Rev: PREL.

RB 8-8-20

2- Deburr if necessary

RB 8-8-20



3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



RB 8-8-20

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

08.08.21 ①

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: Deburr if necessary.

N/A

Date: Wednesday, 8/20/2008 10:08:30 AM
User: David Duval

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ACCESS PANEL

Job Number: 05038

Part Number: D37055

Job Number:



Seq. #: Machine Or Operation: Description:

6.0

QC5



INSPECT WORK TO CURRENT STEP

**ENGINEERING
APPROVAL**



Comment: INSPECT WORK TO CURRENT STEP

08.08.22

08.08.22

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

08-08-22

8.0

POWDER COATING

POWDER COATING



m102316



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

7:40

OVEN TEMPERATURE:

320°

FINISH TIME:

8:10

08-08-25

08/08/22

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-08-22

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

FOR ENGINEERING USE ONLY

08.08.22

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/17

08.08.22

Job Completion



charge to w/o # 00224A

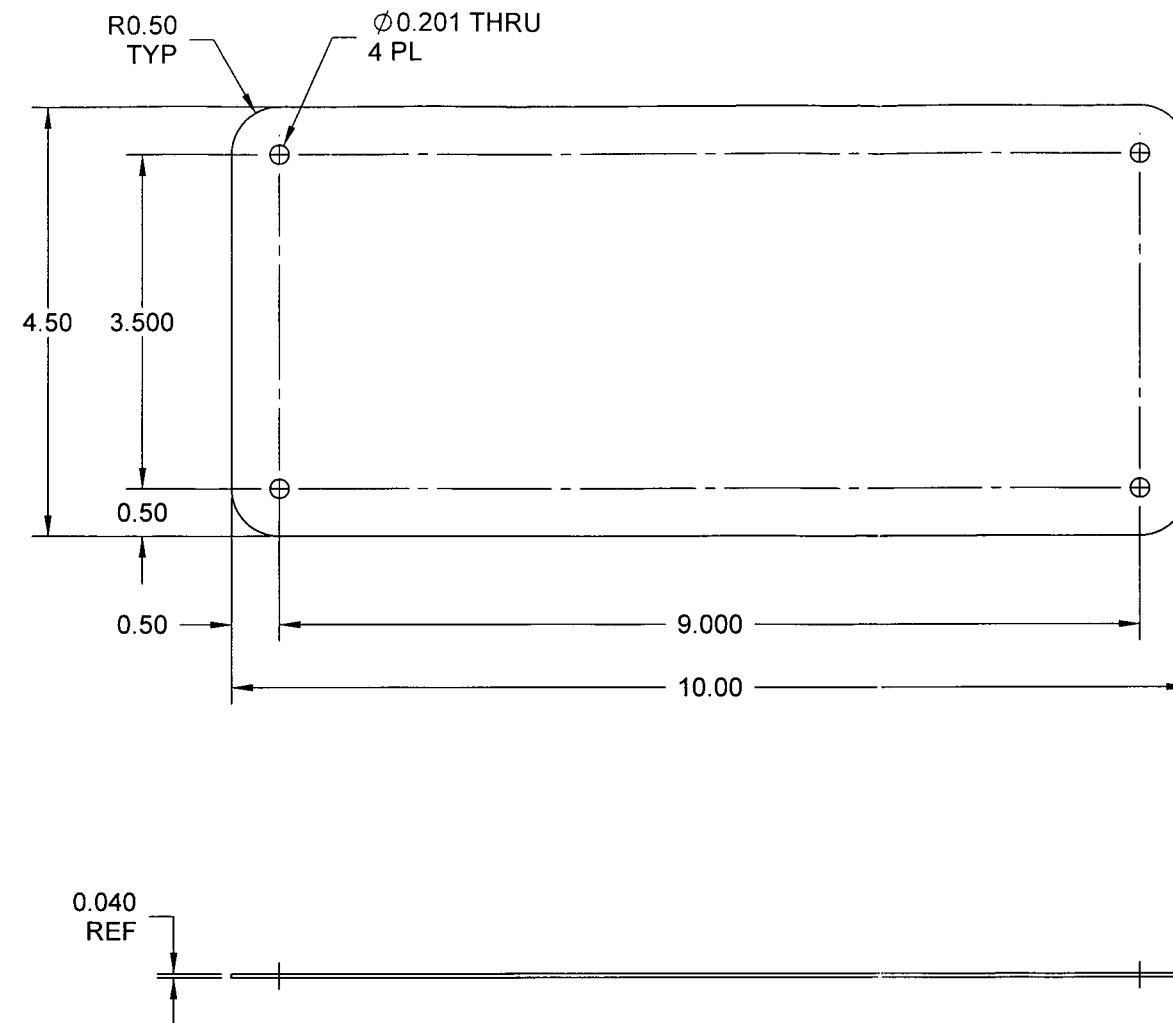
POSITIVE RECALL

EFFECTIVE

08.08.22 AUTH

RELEASED

DATE 09.02.17



D3705-5 ACCESS PANEL

PRELIMINARY ISSUE
08.08.22

PROTOTYPE
08.08.20

D3705-5 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.040 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3705-5" USING WHITE FINE POINT PERMANENT INK MARKER
- 8) WEIGHT: 0.17 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3705	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		INSTRUMENT PANEL ASS'Y	NTS
DATE	08.08.07	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

Date: Wednesday, 8/20/2008 10:08:30 AM
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Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : ACCESS PANEL
 Job Number : 05038
 Estimate Number : 13556
 P.O. Number :
 This Issue : 8/20/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : 1/1 Type : SMALL /MED FAB
 Previous Run :
 Written By : AD 08/08/20
 Checked & Approved By :
 Comment : Est Rev:A 08-08-20 new issue DD verified by:EC

Part Number : D37055
 Drawing Number : D3705 PROTO
 Project Number : N/A
 Drawing Revision : PROTO
 Material :
 Due Date : 8/27/2008

PLATE COATS

Qty: 1 Um: Each

Additional Product

PROTOTYPE

Job Number:



FOR ENGINEERING USE ONLY

Seq. #: Machine Or Operation: Description :

1.0 M6061T6S040 6061-T6 .040 Sheet



P/05374



Comment: Qty.: 0.3281 sf(s)/Unit Total: 0.3281 sf(s)

6061-T6 .040 Sheet

batch 106747 IB 8-8-20

magna.

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3705

Dwg Rev: PREL

Prog Rev: PREL

IB 8-8-20

2- Deburr if necessary

IB 8-8-20



3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



IB 8-8-20



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



SECOND CHECK

108-08-21 ①



Comment: SECOND CHECK

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



N/A



Comment: Deburr if necessary.

Receiving Report

Date: 8/11/97
Supplier: M&L

Batch No: M106747
Dart P/O: 5374

Packing Slip: Yes ☒ No ☐
Invoice: Yes ☐ No ☒
Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☒ No ☐ N/A ☐
Waybill Attached: Yes ☐ No ☒ N/A ☐
Shipment Complete: Yes ☒ No ☐ N/A ☒
QC6 Inspection 8/26/97 N/A ☒
Work Order N/A ☒

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments
M606176307307000		12	20	0	8	
M606176305000000		12	20	0	8	

Initials of receiver (if shipment OK) Level 12

Production/Admin:
Date: 08/11/97
Received/Costing: RLD 42/2
Initial: CA

Location

H:\FORMS\Purchasing\approved p rch\RECREPORT R D

Sub-Total
G.S.T.

602.00
30.10

TOTAL →

632.10

FRAIS D'ADMINISTRATION DE 1½% PAR MOIS (18% PAR ANNÉE) SUR COMPTE PASSÉ DÙ.
LE PRÉSENT CONTRAT SERA RÉGI PAR LES LOIS DE LA PROVINCE DE QUÉBEC ET COMME
AYANT PRIS NAISSANCE DANS LE DISTRICT JUDICIAIRE DE MONTRÉAL.
ADMINISTRATION CHARGES OF 1½% PER MONTH (18% PER YEAR) ON OVERDUE ACCOUNTS.
THE PRESENT AGREEMENT SHOULD BE GOVERNED BY THE QUEBEC LEGISLATION AND SHOULD
BE CONSIDERED AS HAVING ORIGINATED IN THE JUDICIAL DISTRICT OF MONTREAL.

BR 690

DOC : V/0080168742 DATE : 2005-09-27 PROD. REF. : 0000182211/007 NRST : 65947/07 PAGE : 1 / 1 INSPECTION CERTIFICATE

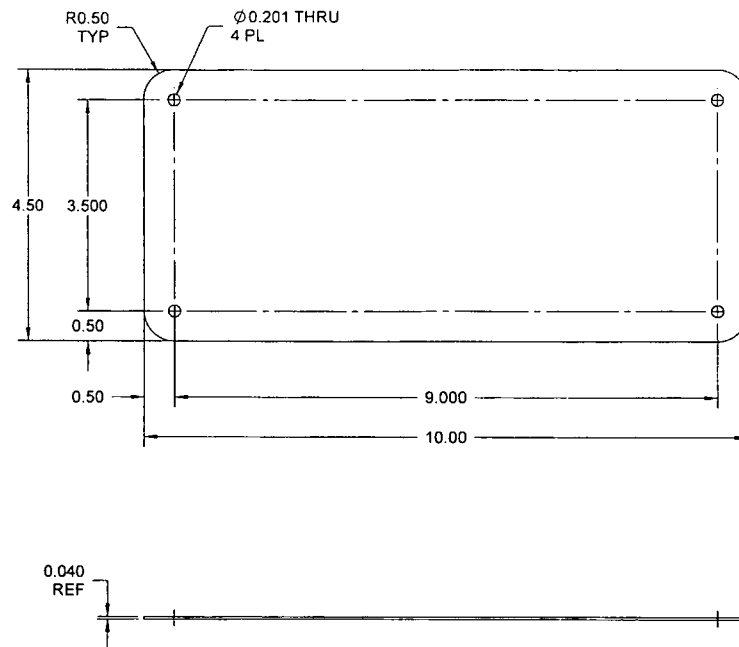


CUSTOMER : CORUS ALUMINIUM ROLLED PRODUCTS US
475 N. MARSHALL ROAD, SUITE 400
SCARSDALE, NY 11583 USA
YOUR ORDER NUMBER : 604746 (Trade) FOR 650429D007
OUR ORDER NUMBER : 65947/07
DOCUMENT NUMBER : V/0080168742
DESCRIPTION : 146" X 48" X .04"
DIMENSIONS : 146" X 48" X .04"
ARTICLE NO. : 1463151

CHEMICAL COMPOSITION (%)		OTHERS : EACH		TOTAL		MIN		MAX	
SI	FE	CU	NI	NO	CR	TI	ZN	0.05	0.15
0.40	0.7	0.15	0.15	1.2	0.15	0.03	0.01	0.05	0.15
MAX	0.8	0.15	0.15	1.2	0.15	0.03	0.01	0.05	0.15
MIN	0.40	0.15	0.15	1.2	0.15	0.03	0.01	0.05	0.15

MECHANICAL PROPERTIES		TEST-NUMBER		MIN		MAX	
1 N/12 = 1 MPa = 0.145 KSI	1 N/12 = 1 MPa = 0.145 KSI	1463151	1463151	0.15	0.15	0.15	0.15
1 N/12 = 1 MPa = 0.145 KSI	1 N/12 = 1 MPa = 0.145 KSI	1463151	1463151	0.15	0.15	0.15	0.15

HEAD OF LABORATORY, XAVIER SCHEIDT
OCT 31 2005
CORUS ALUMINIUM ROLLED PRODUCTS - Corus Aluminum Extrusions



D3705-5 ACCESS PANEL

D3705-5 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.040 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3705-5" USING WHITE FINE POINT PERMANENT INK MARKER
- 8) WEIGHT: 0.17 lbs

05038

UNDER REVIEW
05.01.14

RELEASED
09/12/14

DESIGN	<i>MD SR MB</i>	DART AEROSPACE LTD	
DRAWN	<i>MD SR MB</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>MD SR MB</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>MD SR MB</i>	D3705	SHEET 5 OF 5
APPROVED	<i>MD SR MB</i>	TITLE	SCALE
DE APPR.	<i>MD SR MB</i>	INSTRUMENT PANEL ASS'Y	
DATE	08.08.07	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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